

# Work Order ID 55713

January 28, 2010 11:05:17 AM



Page 1

Item ID: D3954-3

Accept



Setup Start



Revision ID:

Item Name: GWT Knob

Stop



Start Date: 1/29/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 2/15/2010 Req'd Qty: 16.00



Customer:



Reference:

Approvals: Process Plan: MF

Date: 10-1-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3954

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3854

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

R 10-2-2

9/30/02/04 (20)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-2-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




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Item ID: D3954-3	Accept		Setup	Start	
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Required Date: 2/15/2010	Req'd Qty: 16.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	=> 8/10/08			counter (x20)			
130  Mill Conv Conventional Milling Machine	Memo 1-OPEN TO TAP DRILL SIZE 2-TAP AS PER DWG D3954	0.00 0.00	LB 10/02/08			(20) /			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	=> 8/10/08			counter (x20)			

W/O:		WORK ORDER CHANGES					
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Revision ID:						
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Required Date:	2/15/2010	Req'd Qty:	16.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  SprayPaint Spray Painting	<i>MI13540</i> Memo 1- MASK THREADS PRIOR TO PAINTING AS PER DWG 2- SPRAY PAINT YELLOW AS PER DWG A/R BATCH: <i>Per Q57005</i>	0.00 0.00							
									<i>20.0</i>
160  QC Quality Control	QC1- Inspect Spray Paint <i>FINISH</i> Memo	0.00 0.00							<i>20.0</i>
170  Packaging Packaging	Identify as per dwg & Stock Location: <i>102</i> Memo	0.00 0.00							<i>20.0</i>

*8 Powdercoat yellow*  
*Start 3:15pm*  
*Finish 3:20pm*  
*Over Tem. 3:45pm*  
*10/02/09*

*BF 10-02-10*

*20.0*

*Rec'd 1/11 (20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Qty 1 taken for HAI 2010. 820 10.02.09.					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Setup Start



Revision ID:

Stop



Item Name: GWT Knob

Start Date: 1/29/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 2/15/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/11

W 10-02-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 55713

Parent Item: D3954-3

Parent Item Name: GWT Knob

Comments:

Start Date: 1/29/2010

Required Date: 2/15/2010

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M1010B0.375X03.500 Purchased No

100

f

13.9600

0.4679

3.



1010-1025 Steel Bar .375 x 3.500



UB 10-2-2

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

13.96

102179

2.46

110740

11.5

110740

20

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

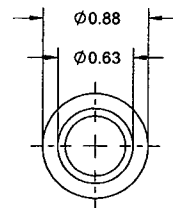


Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

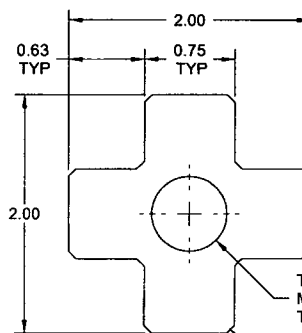
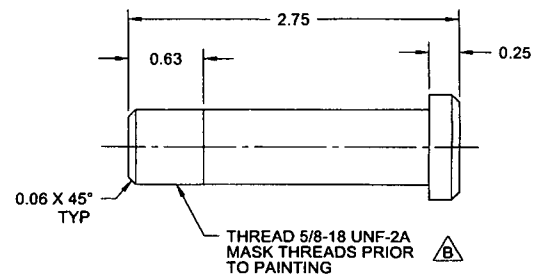
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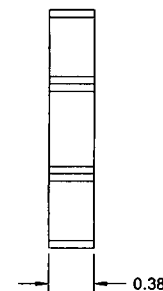
**NOTE:** Date & initial all entries



**D3954-1 GWT PIN**



**D3954-3 GWT KNOB**



**NOTES:**

1) MATERIAL -1: AISI 1010-1025 MILD STEEL ROUND BAR  
PER DART SPEC M1018-R

-3: AISI 1010-1025 MILD STEEL SHEET  
PER DART SPEC MS1010-S

OR: AISI 1010-1025 MILD STEEL BAR  
PER DART SPEC M1010-B

**ALTERNATE MATERIAL:**

-1: AISI 303/304 STAINLESS STEEL ROUND BAR  
REF DART SPEC M303/304R

-3: AISI 303/304 STAINLESS STEEL SHEET  
REF DART SPEC M303/304S

OR: AISI 303/304 STAINLESS STEEL BAR  
REF DART SPEC M303/304B

- 2) FINISH: SPRAY PAINT YELLOW WITH *BERTRAND 601031B* PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -1: 0.26 lbs  
-3: 0.23 lbs

*YELLOW POWDER COAT 10/12/08*

**RELEASED**  
2009-10-19

DESIGN	AJS/DSTOW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3954</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	<b>MISC MACHINED PARTS GWT KIT</b>	
DATE	09.10.15	NTS	

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